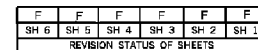


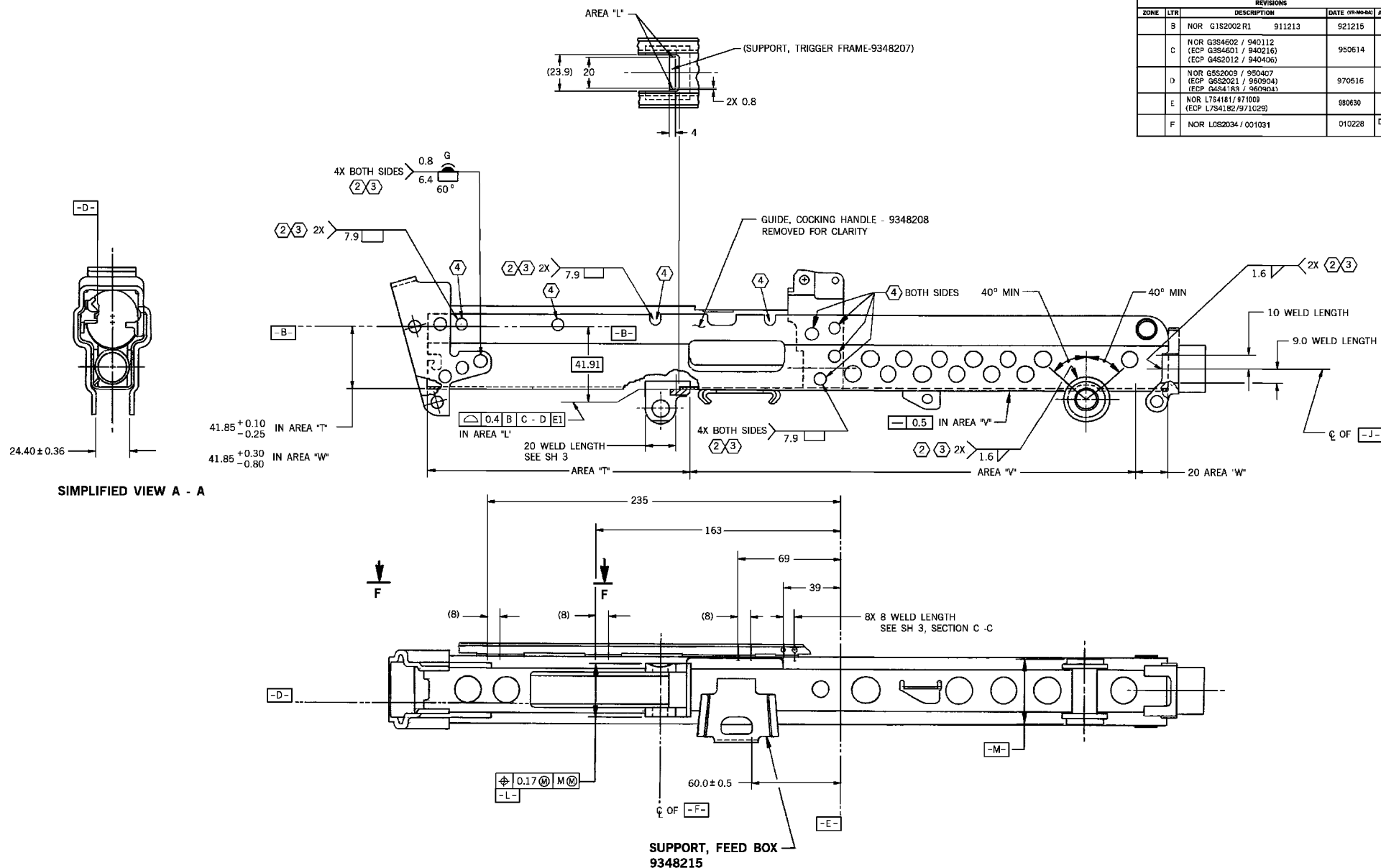
⑩ CHECK FUNCTIONAL CONDITION WITH GAGE 12923171.


0.46 B C-D E1 IN AREA "S"  
0.6 B C-D E1 IN AREA "R"



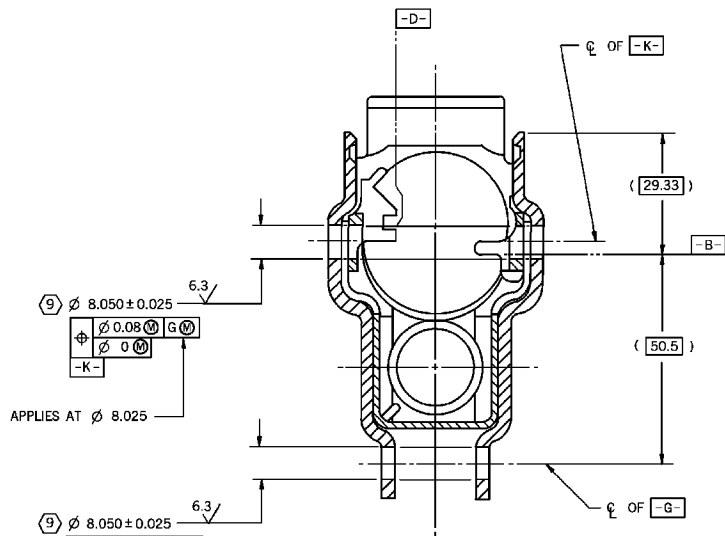
PART NO. 9348202	METRIC
------------------	--------

REVISIONS					
ZONE	LTR	DESCRIPTION	DATE (YY-MM-DD)	APPROV	
	B	NOR G182002 R1 911213 (ECP G384602 / 940112) (ECP G384601 / 940216) (ECP G42012 / 940406)	921215		DR
					DR
	D	NOR G552009 / 950407 (ECP G662021 / 980904) (ECP G454183 / 960904)	970516		DL
					DL
	E	NOR L784181 / 871008 (ECP L784182 / 971229)	880630		DL
					DL
	F	NOR L052034 / 011031	010228		DTG

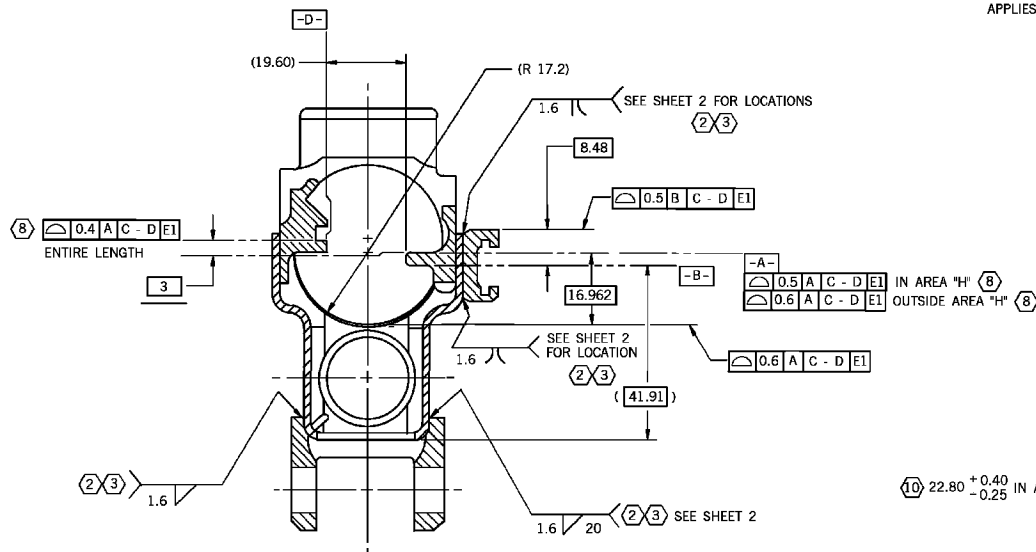


PHIC		A		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES		CONTRACT NUMBER DAAA09-88-C-0982		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICATINNY ARSENAL, NEW JERSEY 07906-5000		
MECHANICAL PROPERTIES				DECIMAL 2 PL. ± 3 DEC. ±		CONTRACTOR FBI MANUFACTURING, INC. DRAWN BY DATE 07/05/00 D. WILSON 830950		<div style="text-align: center; font-size: 2em; font-weight: bold;">RECEIVER</div>		
YP				<div style="text-align: center;">  <p>THIRD ANGLE PROJECTION</p> </div>		CHECKED RD	ENGINEER			
TS						DRAWING APPROVAL <i>[Signature]</i>	SIZE F			CAGE CODE 19200
RA						DESIGN APPROVAL <i>[Signature]</i>	9348202			
BH		9348201	M249 N.G.	NEXT ASSY USED ON	MATL. LING.					
RH		APPLICATION						SCALE 1/1	SHEET 2 OF 6	

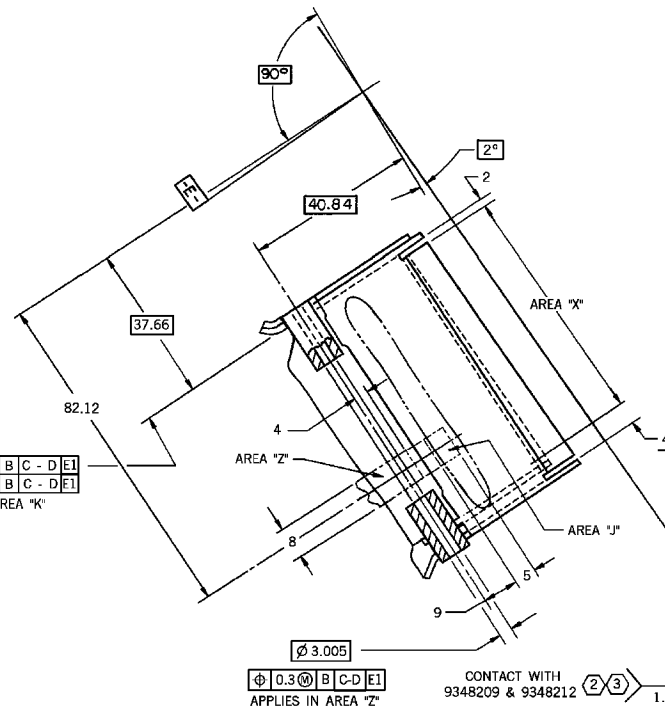
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (OR 98-94)	APPROVED
B	NOR	G1S2002 R1	911213	921215 <i>DLW</i>
C	NOR	G3S4602 / 940112 (ECP G3S4601 / 940216) (ECP G4S2012 / 940406)	950614	<i>DLW</i>
D	NOR	G5S2009 / 950407 (ECP G5S2021 / 960904) (ECP G4S4183 / 960904)	970516	<i>DLW</i>
E	NOR	L7S4181 / 971009 (ECP L7S4182 / 971029)	980630	<i>DLW</i>
F	NOR	L0S2034 / 001031	010228	<i>DTC</i>



SIMPLIFIED SECTION B - B



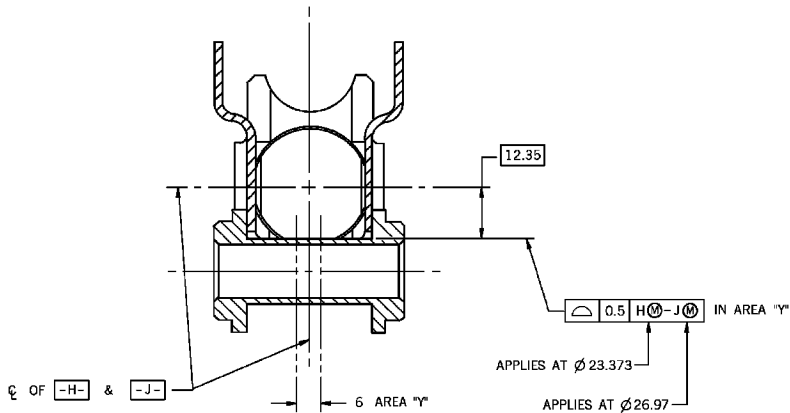
SIMPLIFIED SECTION C - C



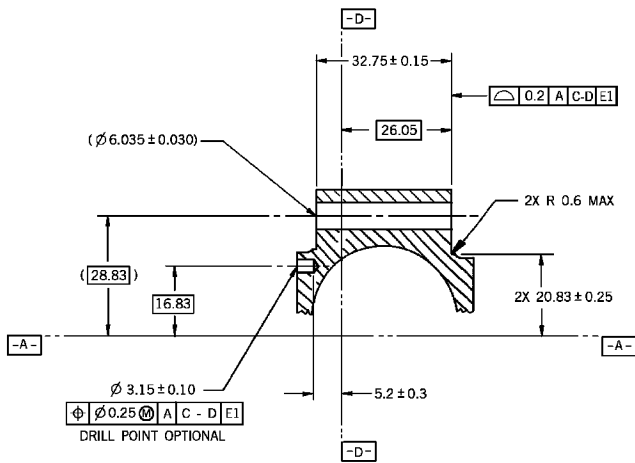
SIMPLIFIED SECTION D - D

PMIC		DO NOT SCALE DRAWING		CONTRACT NUMBER		PART NO. 9348202		METRIC	
A		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		DAAA09-88-C-0982		RECEIVER		U.S. ARMY	
MECHANICAL PROPERTIES		TOLERANCE ON DECIMAL FRACTION		CONTRACTOR		DATE		CENTER, PICATINNY ARSENAL, NEW JERSEY 07806-5000	
Y.P.		2 PL. 1		F.N. MANUFACTURING, INC.		830930			
T.S.		3 PL. 1		DRAWN BY		ENGINEER			
E.P.		THIRD ANGLE PROJECTION		CHECKER					
R.A.				DRAWING APPROVAL					
B.H.		9348201 M249 M.G.		DESIGN APPROVAL					
R.H.		NEXT ASSY USED ON							
		APPLICATION							

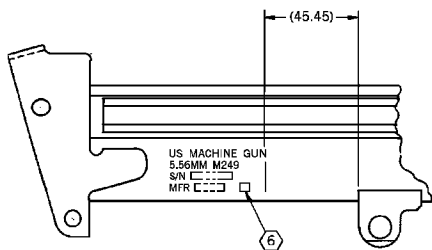
REVISIONS					
ZONE	LTR	DESCRIPTION	DATE	BY	APPROVED
B	NOR	G1S2002 R1	911213	921215	<i>DLW</i>
C	NOR	G3S4602 / 940112 (ECP G3S4601 / 940216) (ECP G4S2012 / 940406)		950614	<i>DLW</i>
D	NOR	G5S2009 / 950407 (ECP G6S2021 / 960904) (ECP G6S4183 / 960904)		970516	<i>DLW</i>
E	NOR	L7S4181 / 861008 (ECP L7S4182 / 971029)		980630	<i>DLW</i>
F	NOR	L0S2034 / 001031		010228	<i>DTC</i>



SECTION E-E  
SCALE 2/1



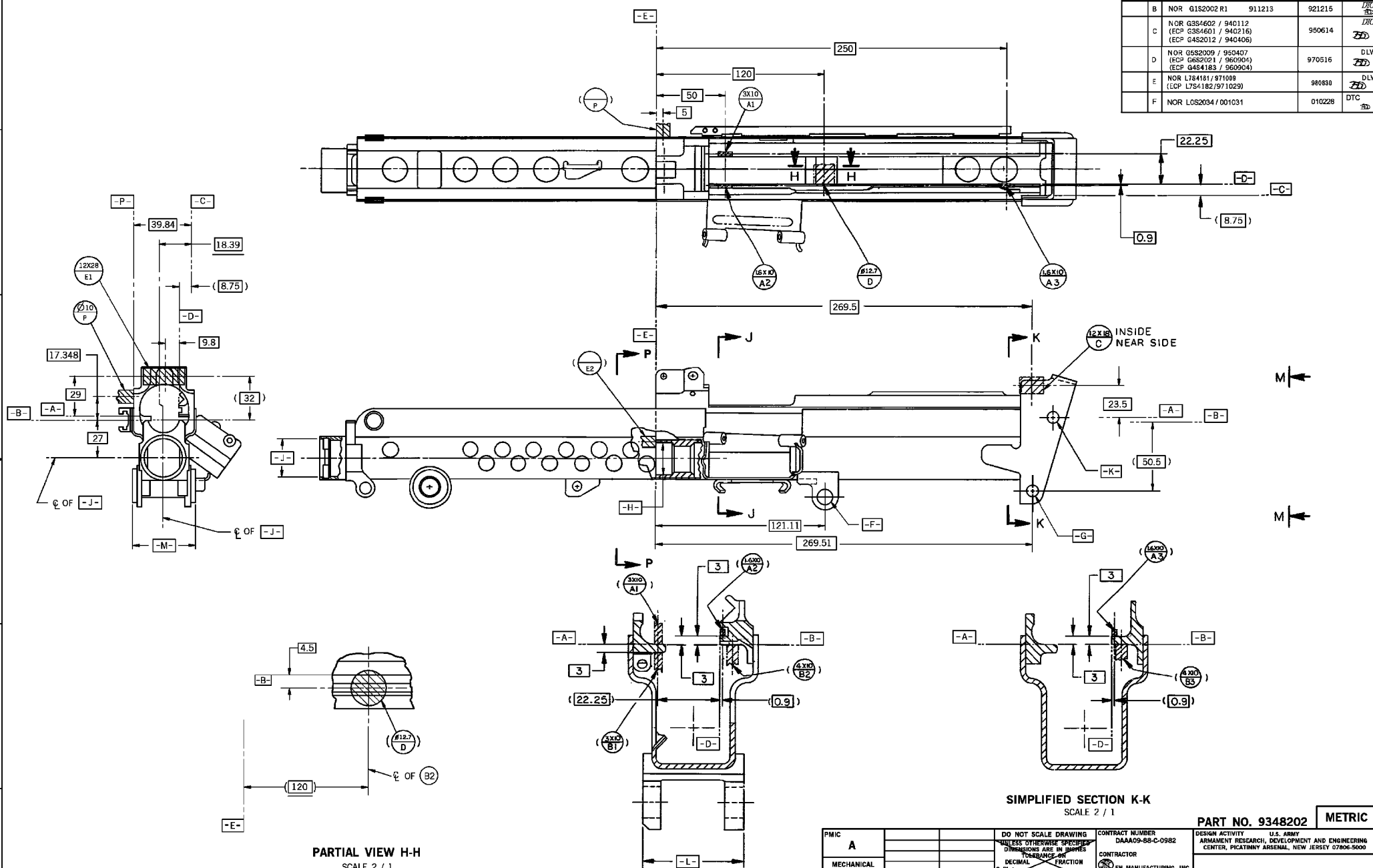
PARTIAL SECTION L-L  
SCALE 2/1



PARTIAL VIEW F-F  
WEAPON MARKING LOCATION

PMIC A		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMAL FRACTION 2 PL ± 0.005 3 PL ± 0.010		CONTRACT NUMBER DAAA09-88-C-0982		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICATINNY ARSENAL, NEW JERSEY 07806-5000	
MECHANICAL PROPERTIES		THIRD ANGLE PROJECTION		CONTRACTOR FN MANUFACTURING, INC.		RECEIVER	
YP		DRAWN BY D. WILSON		DATE 8/30/90		SIZE F 19200	
TS		CHECKER ENGINEER		DESIGN APPROVAL <i>[Signature]</i>		CAGE CODE 9348202	
ELP		MAYL ENG.		DESIGN APPROVAL <i>[Signature]</i>		SCALE 1/1	
BA	9348201	M249 M.G.				UNIT WT. SHEET 4 OF 6	
BH	NEXT ASSY	USED ON					
RH	APPLICATION						

REVISIONS					
ZONE	LTR	DESCRIPTION	DATE (YY-MM-DD)	APPROVED	
B	NOR	G1S2002 R1	911213	921215	DIC
C	NOR	G3S4602 / 940112 (ECP G3S4601 / 940216) (ECP G4S2012 / 940406)		950614	DIC
D	NOR	G5S2009 / 950407 (ECP G6S2001 / 960904) (ECP G4S4183 / 960904)		970516	DLW
E	NOR	L784181 / 971009 (ECP L754182/971029)		980830	DLW
F	NOR	L0S2034 / 001031		010228	DTC



PARTIAL VIEW H-H  
SCALE 2 / 1

SIMPLIFIED SECTION J-J  
SCALE 2 / 1

SIMPLIFIED SECTION K-K  
SCALE 2 / 1

PART NO. 9348202 METRIC

DESIGN ACTIVITY U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING  
CENTER, PICATINNY ARSENAL, NEW JERSEY 07806-5000

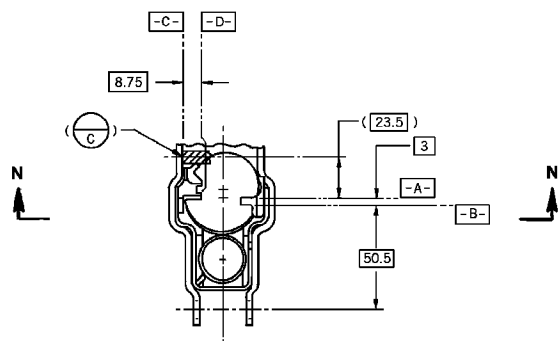
RECEIVER

SIZE F 19200 9348202

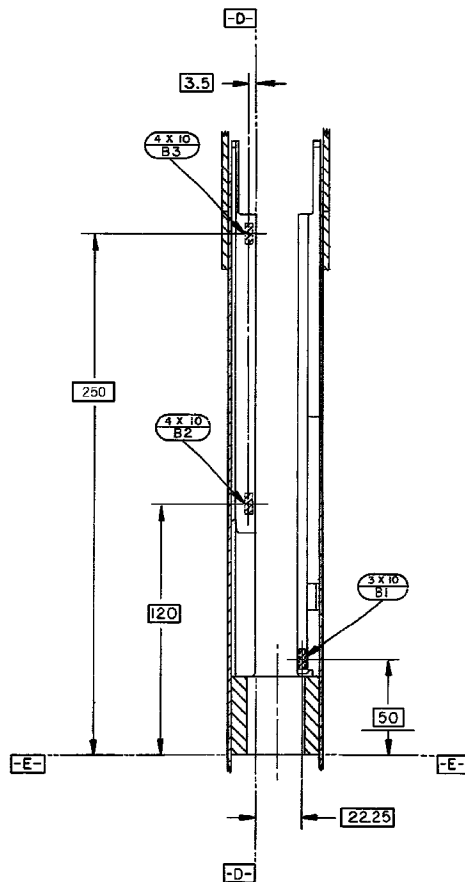
SCALE 1 / 1 UNIT WT. SHEET 5 OF 6

PMIC	A	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES 2 PL + 3 PL - THIRD ANGLE PROJECTION	CONTRACT NUMBER DAAA09-88-C-0982 CONTRACTOR FM MANUFACTURING, INC. DRAWN BY D. WILSON CHECKER ENGINEER	DATE (YY-MM-DD) 8/30/90
MECHANICAL PROPERTIES			DRAWING APPROVAL DESIGN APPROVAL	
YP				
TS				
ES				
BA				
BH	9348201	M249 M.G.		
RH	NEXT ASSY	USED ON		
	APPLICATION			

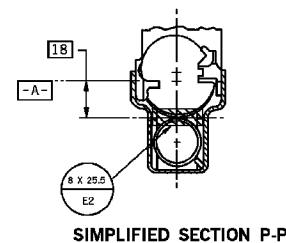
REVISIONS					
ZONE	LTR	DESCRIPTION	DATE (Y-M-D)	APPROVED	
B	NOR	Q192002 R1	911213	921215	DIC RD
C	NOR	G3S4602 / 940112 (ECP G3S4601 / 940215) (ECP G4S2012 / 940406)		950614	DIC RD
D	NOR	G5S2009 / 950407 (ECP G6S2021 / 950904) (ECP G4S4183 / 950904)		970516	DLW RD
E	NOR	L7S4181 / 971009 (ECP L7S4182 / 971029)		980630	DLW RD
F	NOR	L0S2034 / 001031		010228	DTC RD



PARTIAL VIEW M - M



SIMPLIFIED SECTION N - N



SIMPLIFIED SECTION P-P

PMIC <b>A</b>		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PL - DECIMAL 3 PL - FRACTION THIRD ANGLE PROJECTION		CONTRACT NUMBER DAAA09-88-C-0982 CONTRACTOR FM MANUFACTURING, INC. DESIGNED BY D. WILSON CHECKER RD DATE (Y-M-D) 830930 ENGINEER		PART NO. 9348202 DESIGN ACTIVITY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICATINNY ARSENAL, NEW JERSEY 07806-5000		RECEIVER	
MECHANICAL PROPERTIES YP TS EL RA BH RH		9348201 NEXT ASSY M249 M.G. USED ON APPLICATION		MATERIAL MATERIAL ENGINEER		SIZE F 19200 CAGE CODE 9348202		SCALE 1 / 1 UNIT WT. SHEET 6 OF 6	
				DRAWING APPROVAL DESIGN APPROVAL FPMH					

# NOTICE OF REVISION (NOR)

This revision described below has been authorized for the document listed.

1. DATE  
(YYMMDD)  
000731

Form Approved  
OAH NO. 0704-0188

Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden to Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302 and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188) Washington DC 20503.

PLEASE DO NOT RETURN YOUR COMPLETED TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT / PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.

2. PROCURING  
ACTIVITY NO.  
LOS2034

3. DODACC

4. ORIGINATOR

b. ADDRESS (Street, City, State, Zip Code)

5. CAGE CODE

6. NOR NO.

a. TYPED NAME (First, Middle Initial, Last)

AMSTA-AR-CCL-A

19200

LOS2034 -  
F9348202

Brian Donovan

ARDEC

Picatinny Arsenal, NJ 07806-5000

7. CAGE CODE  
19200

8. DOCUMENT NO.  
F 9348202

9. TITLE OF DOCUMENT

RECEIVER

10. REVISION LETTER  
a. CURRENT  
b. NEW

11. ECP NO.  
00SAW-002

12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES

MACHINE GUN, 5.56MM; M249

NOR SH. 1  
OF 1

13. DESCRIPTION OF CHANGE:

CHANGE: ON SHEET 1 IN NOTE 3:

FROM:

"AWS 2.4-86"

TO:

"AWS A2.4-86"

UPDATE SHEETS 2-6 OF 6 TO THE NEXT REVISION LEVEL TO MAINTAIN CONTINUITY.

## 11. THIS SECTION FOR GOVERNMENT USE ONLY

- a. (X) one
  - (1) Existing document supplemented by the NOR may be used in manufacturing.
  - (2) Revised document must be received before manufacturer may incorporate this change.
  - (3) Cancellation of master document shall make above revision and furnish revised document.

b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT

c. TYPED NAME (First, Middle Initial, Last)

TACOM-ARDEC, FOMSTA-AR-CCL-F

d. TITLE

e. SIGNATURE

f. DATE SIGNED



Chief, CCAO F100 & F105 SPI Team

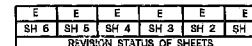
15.a. ACTIVITY ACCOMPLISHING REVISION

b. REVISION COMPLETED (SIGNATURE)

c. DATE SIGNED  
(YYMMDD)

⑩ CHECK FUNCTIONAL CONDITION WITH GAGE 12923171 .

	0.46	B	C-D	E1	IN AREA "S"
	0.6	B	C-D	E1	IN AREA "R"



SMCAR FORM 69, 1 DEC 87 (TEMP) REPLACES SMCAR FORM 69, 1 JUL 87 (TEMP) WHICH MAY BE USED UNTIL EXHAUSTED.



1

D



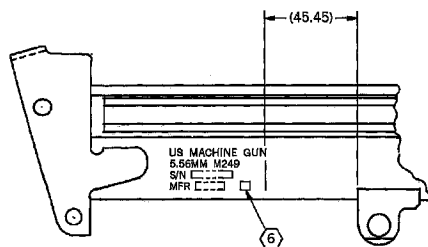
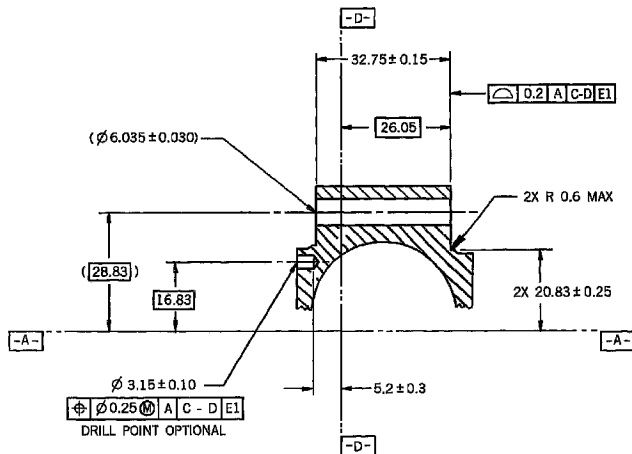
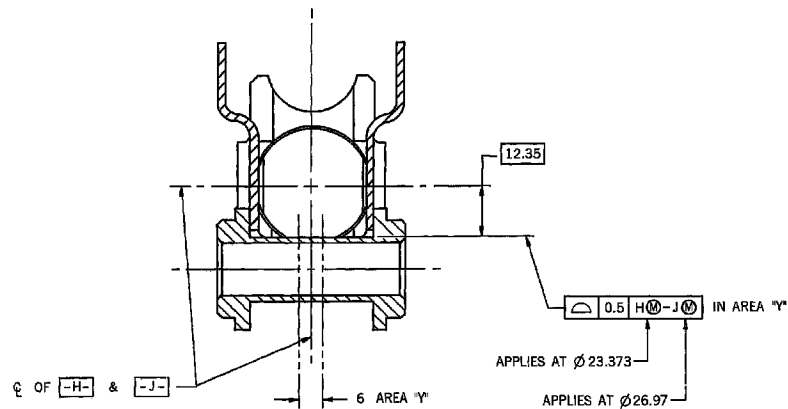
■

1. a

**A**

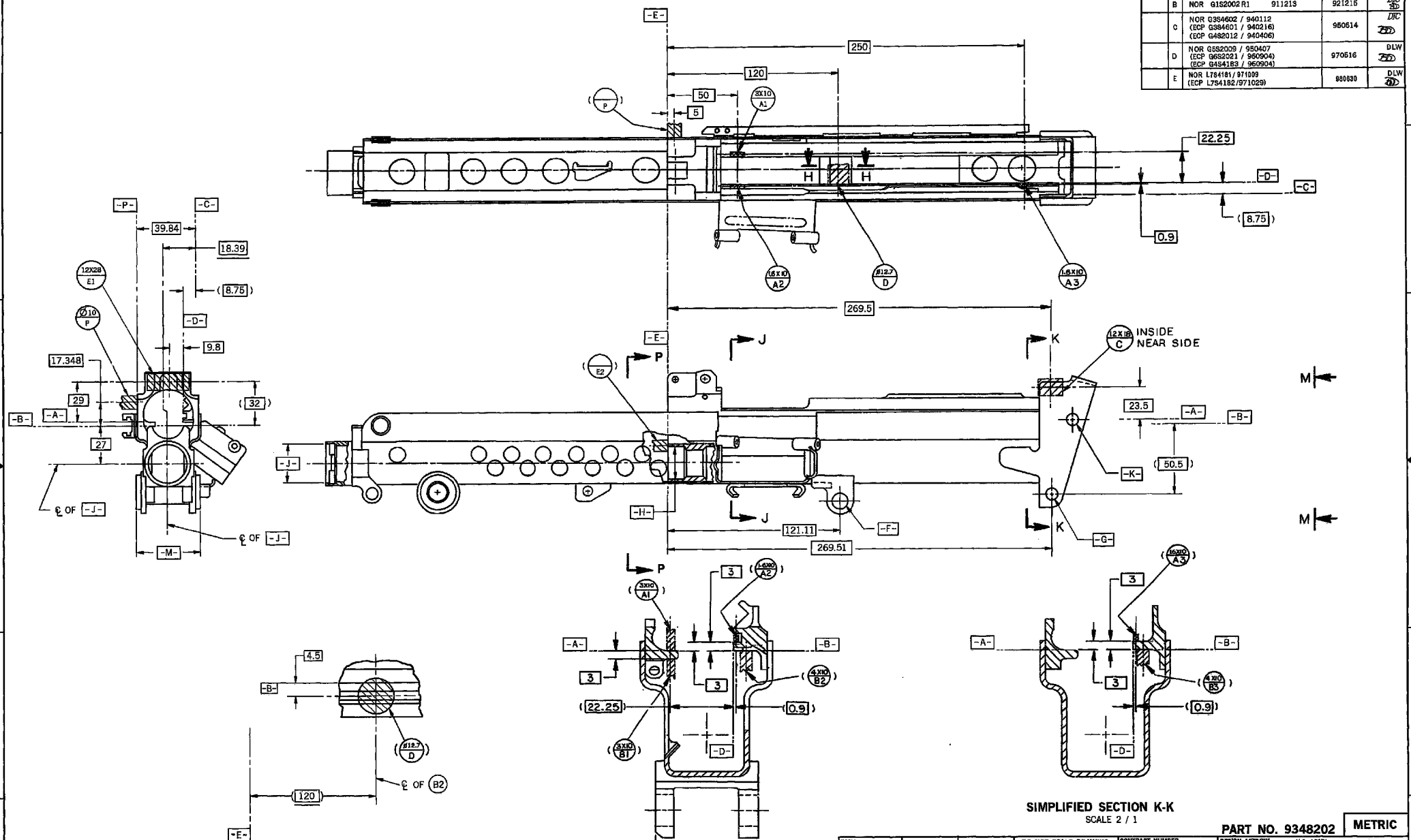


REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YY-MM-DD)	APPROVED
B	NOR	G182002 R1	911218	921215 DIC
C		NOR G334602 / 940112 (ECP G334601 / 940216) (ECP G482012 / 940406)	950614	DIC DW
D		NOR G582009 / 950407 (ECP G682021 / 960904) (ECP G684183 / 960904)	970516	DW DW
E		NOR L784191/981008 (ECP L784182/971029)	980630	DW DLW



PMIC		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:		CONTRACT NUMBER DAAA09-88-C-0982		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER, PICTANTY ARSENAL, NEW JERSEY 07805-2000	
A		DECIMAL 2 PL. 3 PL.		CONTRACTOR FH MANUFACTURING, INC.		RECEIVER	
MECHANICAL PROPERTIES		FRACTION 2 PL. 3 PL.		DRAWN BY D. WILSON		SIZE F 19200	
VP		THIRD ANGLE PROJECTION		CHECKED D. WILSON		CASE CODE 9348202	
YS		WALT ENL.		ENGINEER		SCALE 1/1	
ELZ		APPLICATION		DRAWING APPROVAL		UNIT WT.	
BA		NEXT ASSY		DESIGN APPROVAL		SHEET 4 OF 6	
BH		USED ON		[Signature]		[Signature]	
RH							

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (ISSUED)	APPROVED
	B	NOR GIS2002 R1	911213	921215 DLC
	C	NOR G3S4602 / 940112 (ECP G3S4601 / 940216) (ECP G4S2012 / 940406)	950614	DLC
	D	NOR G5S2009 / 950407 (ECP G6S2001 / 950904) (ECP G4S4183 / 950904)	970516	DLW
	E	NOR L7S4181 / 971009 (ECP L7S4182 / 971029)	980830	DLW



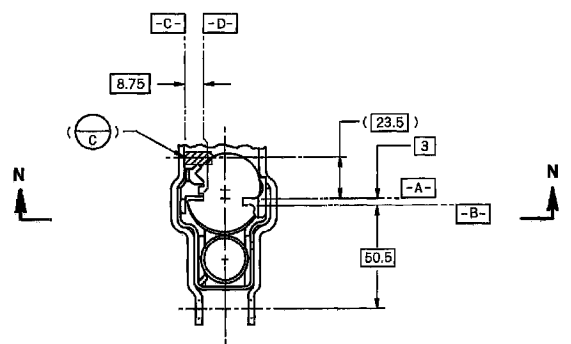
PARTIAL VIEW H-H  
SCALE 2 / 1

SIMPLIFIED SECTION J-J  
SCALE 2 / 1

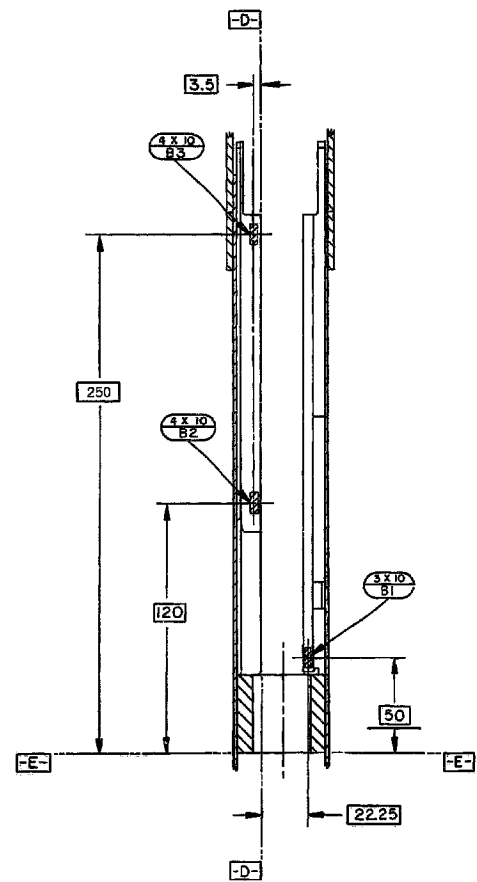
SIMPLIFIED SECTION K-K  
SCALE 2 / 1

PMIC		DO NOT SCALE DRAWING		CONTRACT NUMBER		PART NO. 9348202		METRIC	
A		UNLESS OTHERWISE SPECIFIED		DAAAD-88-C-0982		U.S. ARMY			
MECHANICAL		DIMENSIONS ARE IN INCHES		CONTRACTOR		ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING			
VP		TOLERANCE		PM MANUFACTURING, INC.		CENTER, PISCATAWAY ARSENAL, NEW JERSEY 07906-5000			
TYS		DECIMAL		DRAWN BY		RECEIVER			
ELZ		2 PL ±		D. WILSON					
RA		3 PL ±		CHECKED					
BH		THIRD ANGLE PROJECTION		ENGINEER					
RH		9348201		DRAWING APPROVAL		SIZE		F 19200	
		NEXT ASSY USED ON		DESIGN APPROVAL		SCALE		1 / 1	
		APPLICATION				JURY WT.		9348202	
						SCALE		1 / 1	
						JURY WT.		9348202	
						SCALE		1 / 1	
						JURY WT.		9348202	

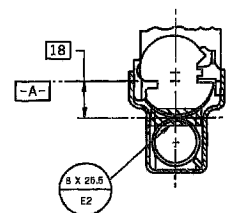
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR-MO-DY)	APPROVED
	B	NOR G152002 R1 911213	921215	DLW 20
	C	NOR G384602 / 940112 (ECP G384601 / 940216) (ECP G452012 / 940406)	960614	DLW 20
	D	NOR G582009 / 950407 (ECP G652021 / 960904) (ECP G454183 / 960904)	970516	DLW 20
	E	NOR L784181 / 971008 (ECP L784182 / 971029)	980630	DLW 20



PARTIAL VIEW M - M



SIMPLIFIED SECTION N - N



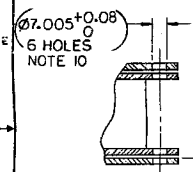
SIMPLIFIED SECTION P-P

PMIC		DO NOT SCALE DRAWING		CONTRACT NUMBER		PART NO. 9348202		METRIC	
A		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES		DAAA09-88-C-0882		DESIGN ACTIVITY		U.S. ARMY	
MECHANICAL PROPERTIES		DECIMAL FRACTION		CONTRACTOR		ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING		CENTER, PHOENIX ARSENAL, NEW JERSEY 07806-5000	
Y1		2 PL ±	×	FEN MANUFACTURING, INC.		RECEIVER			
Y2		3 PL ±	×	THIRD ANGLE PROJECTION		SIZE		CAGE CODE	
Y3				DRAWING BY DATE (YR-MO-DY)		F 19200		9348202	
Y4				CHECKED BY DATE (YR-MO-DY)		SCALE		UNIT WT.	
Y5				D.WILSON 830330		1 / 1		SHEET 5 OF 6	
Y6				ENGINEER		FPH			
Y7				DRAWING APPROVAL					
Y8				DESIGN APPROVAL					
Y9									
Y10									
Y11									
Y12									
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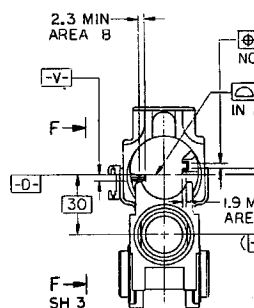
- NOTES:-

- NOTES:-
- 1- SPEC. MIL-W-13855 AND ANSI Y14.5M-82 APPLY.
  - 2- UNLESS OTHERWISE SPECIFIED, WELDING SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF MIL-STD-1261 CLASS II, USING FILLER METAL CONFORMING TO SPEC MIL-R-5031, CLASS I.
  - 3- PROJECTION WELDING SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF SPEC MIL-W-12332.
  - 4- INTERPRETATION OF WELDING SYMBOLS SHALL BE IN ACCORDANCE WITH AWS 2.4-79.
  - 5- SURFACES OF BODY, RECEIVER-9348203 AND SUPPORT, TRIGGER FRAME-9348207 AND SUPPORT, BARREL-9348204 SHALL BE IN CONTACT DURING WELDING.
  - 6- FOR MARKING SEE SHEET 3.
  - 7- FOR DATUM TARGET AREAS SEE SHEETS 3 AND 4.
  - 8- PROTECTIVE FINISH:- FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
  - 9- POSITIONAL TOLERANCE APPLIES WITHIN AREA "X". SEE SHEET 4.
  - 10- THE 7MM DIA HOLES IN THE BLOCK, REAR-9348211 ARE CONSTRUCTION HOLES USED TO POSITION THE BLOCK FOR WELDING. FOR FINAL LOCATION AND HOLE SIZES, SEE SHEET 3.

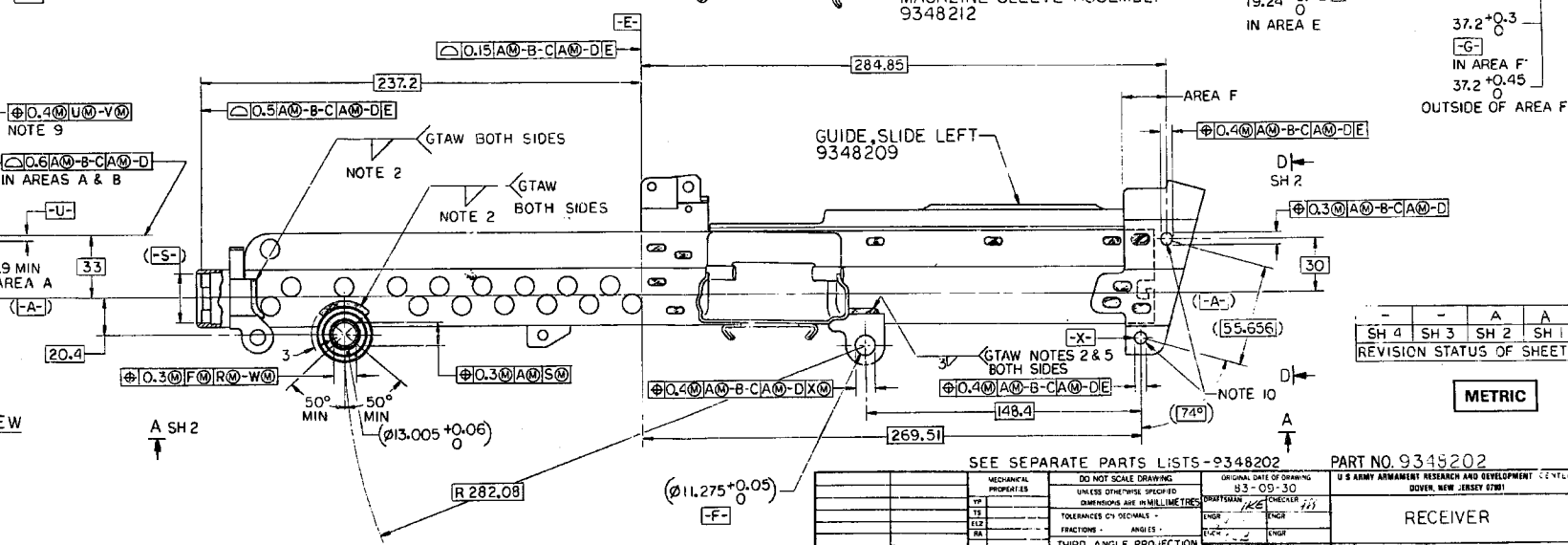
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
-	PRODUCTION RELEASE ERR W352507	630930	119 Sgt
A	NORW552548 36Q106	860716	FL



PARTIAL SECTION G-G



SIMPLIFIED VIEW




-	-	A	A
SH 4	SH 3	SH 2	SH 1
REVISION STATUS OF SHEETS			

Metric	Value
Overall Score	85
Accuracy	92
Precision	88
Recall	80
F1 Score	85
Confidence	90
Efficiency	75
Scalability	82
Flexibility	78
Reliability	95
Security	80
Compliance	70
Interoperability	85
Performance	90
Usability	88
Accessibility	75
Portability	80
Compatibility	78
Integration	82
Documentation	70
Support	85
Training	75
Implementation	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85
Development	75
Testing	80
Deployment	78
Monitoring	82
Maintenance	75
Upgrade	80
Migration	78
Backup	85
Recovery	75
Disaster	80
Business	78
Continuity	82
Resilience	75
Adaptability	80
Innovation	78
Research	85</

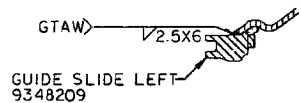
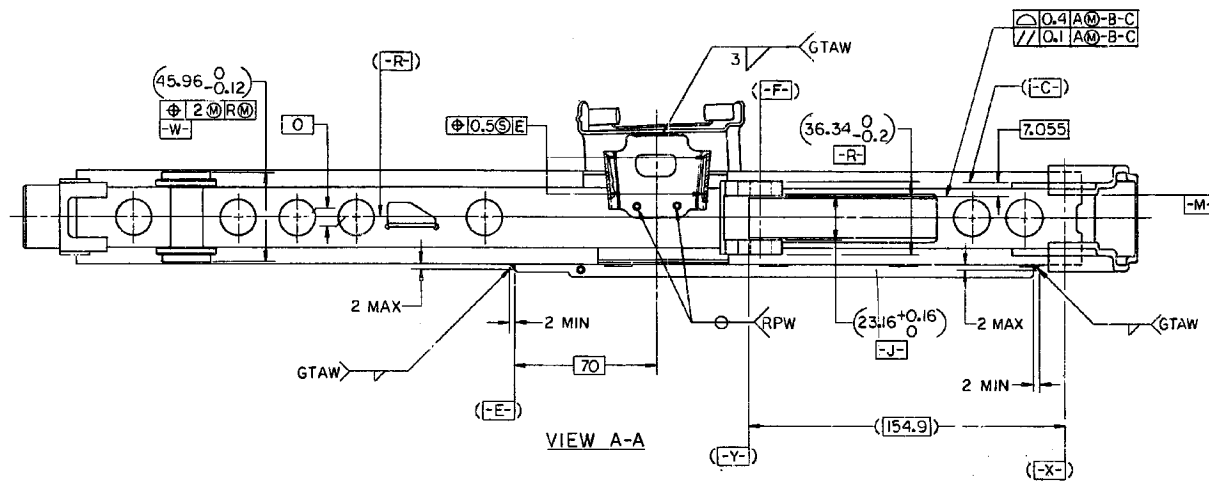
SEE SEPARATE PARTS LISTS-9348202

PART NO. 9345202

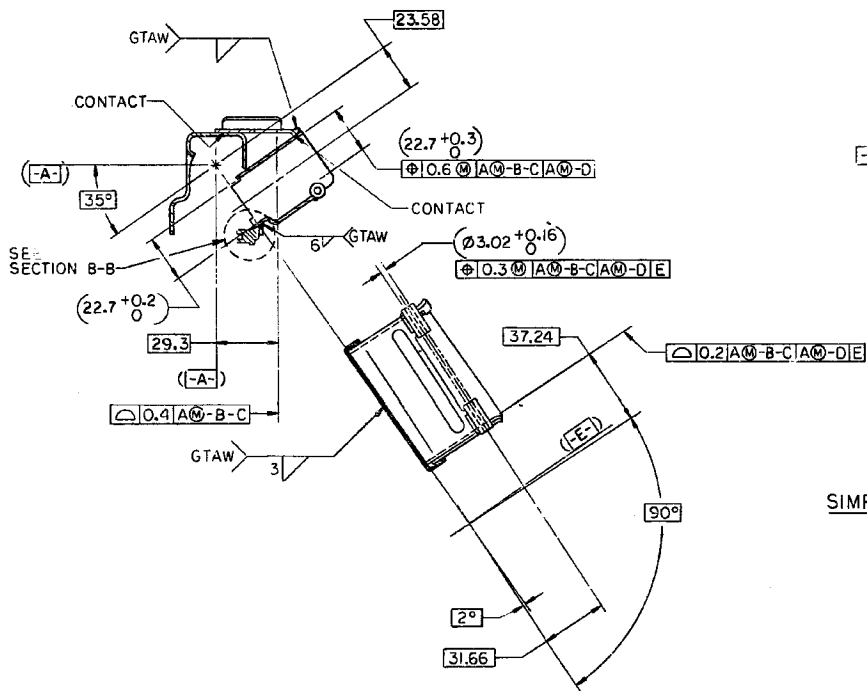
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				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS		DRAWN BY <i>ACE</i> CHECKED BY <i>jis</i>		RECEIVER	
		TYP		TOLERANCES CY DECIMALS		UNGR			
		FR		FRACTIONS		UNGR			
		FIN		ANDS		UNGR			
9348201		MG, M249		THIRD ANGLE PROJECTION				SIZE F FSCM NO.	
HEAT ASSY		USED ON				19200		9348202	
APPLICATION		MIL				SCALE 1/1		SHEET 1 OF 1	

3E12101013 6EX C9 / 12-03--3

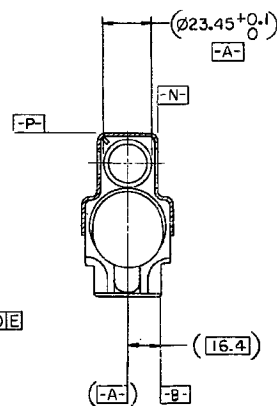
REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
-	PRODUCTION RELEASE	830930	SP
-	ERR W352507		
A	NOR W552548 B6 0106	860716	JP



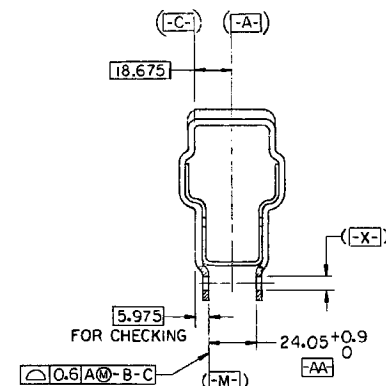
SECTION B-B



SIMPLIFIED SECTION B-B



SIMPLIFIED SECTION C-C



SIMPLIFIED VIEW D-D

METRIC

PART NO. 9348202

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
COVER, NEW JERSEY 07811

RECEIVER

FSC NO. 9348202

SCALE 1/1 UNIT WT SHEET 2

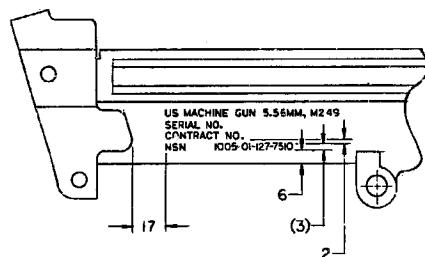
3612101013 REV C9/13-08-83

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS		ORIGINAL DATE OF DRAWING 83-09-30	
YP		TOLERANCES ON DECIMALS -		DRAFTSMAN	CHECKER
TS		FRACTIONS -		ENGR	ENGR
EL		ANGLES -		ENGR	ENGR
RA		THIRD ANGLE PROJECTION			
BY					
RH					
APP					

SYN	DESCRIPTION	DATE	APPROVAL
-	PRODUCTION RELEASE ERR W352507	830830	1/4 [Signature]

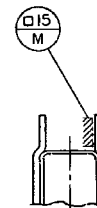
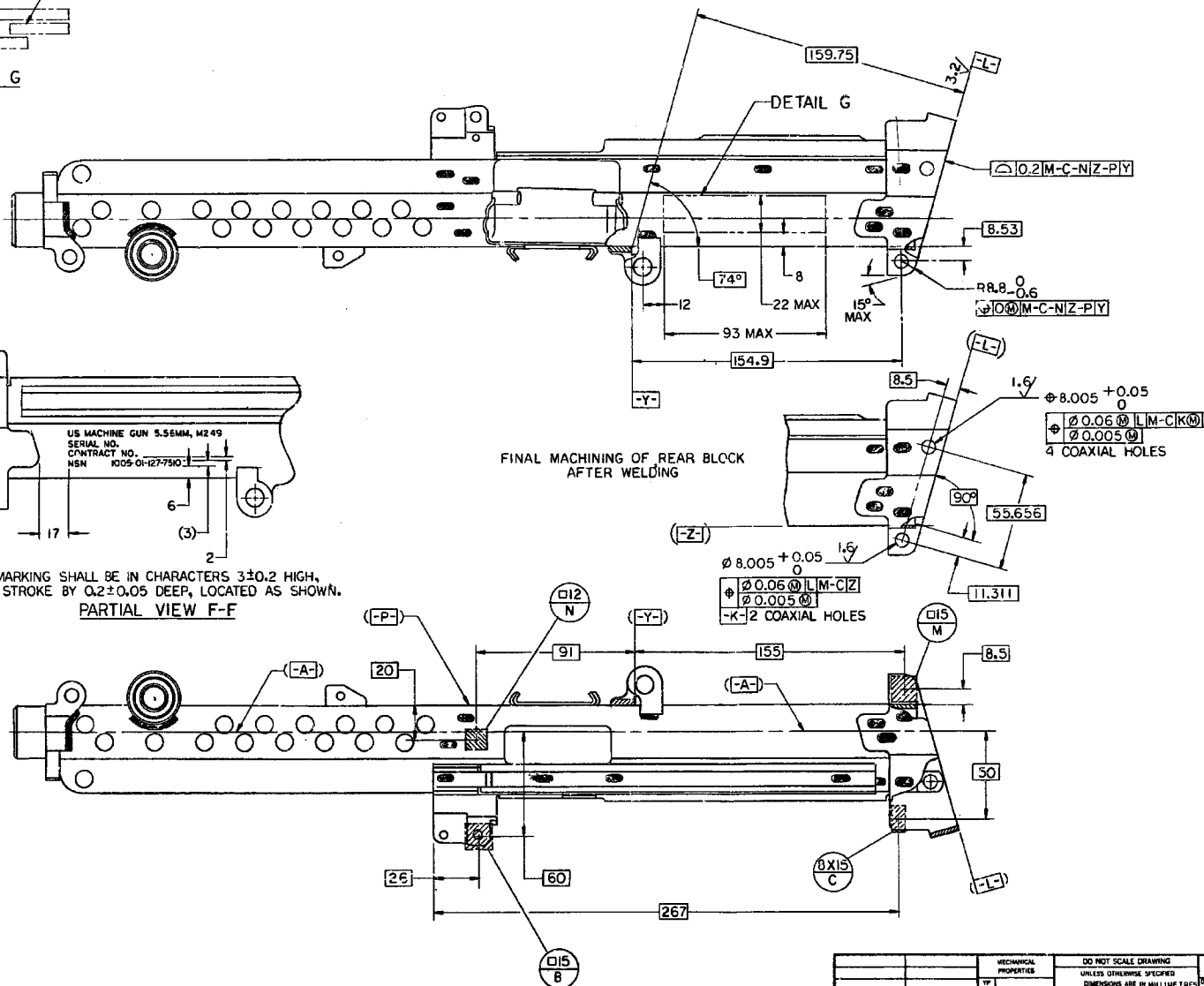
MFR NAME  
MFR TRADE MARK (OPTIONAL)  
MFR SERIAL NO. (OPTIONAL)  
MFR FSCM NO.

DETAIL G



MARKING SHALL BE IN CHARACTERS  $3 \pm 0.2$  HIGH,  
0.5 STROKE BY  $0.2 \pm 0.05$  DEEP, LOCATED AS SHOWN.  
PARTIAL VIEW F-F

FINAL MACHINING OF REAR BLOCK  
AFTER WELDING



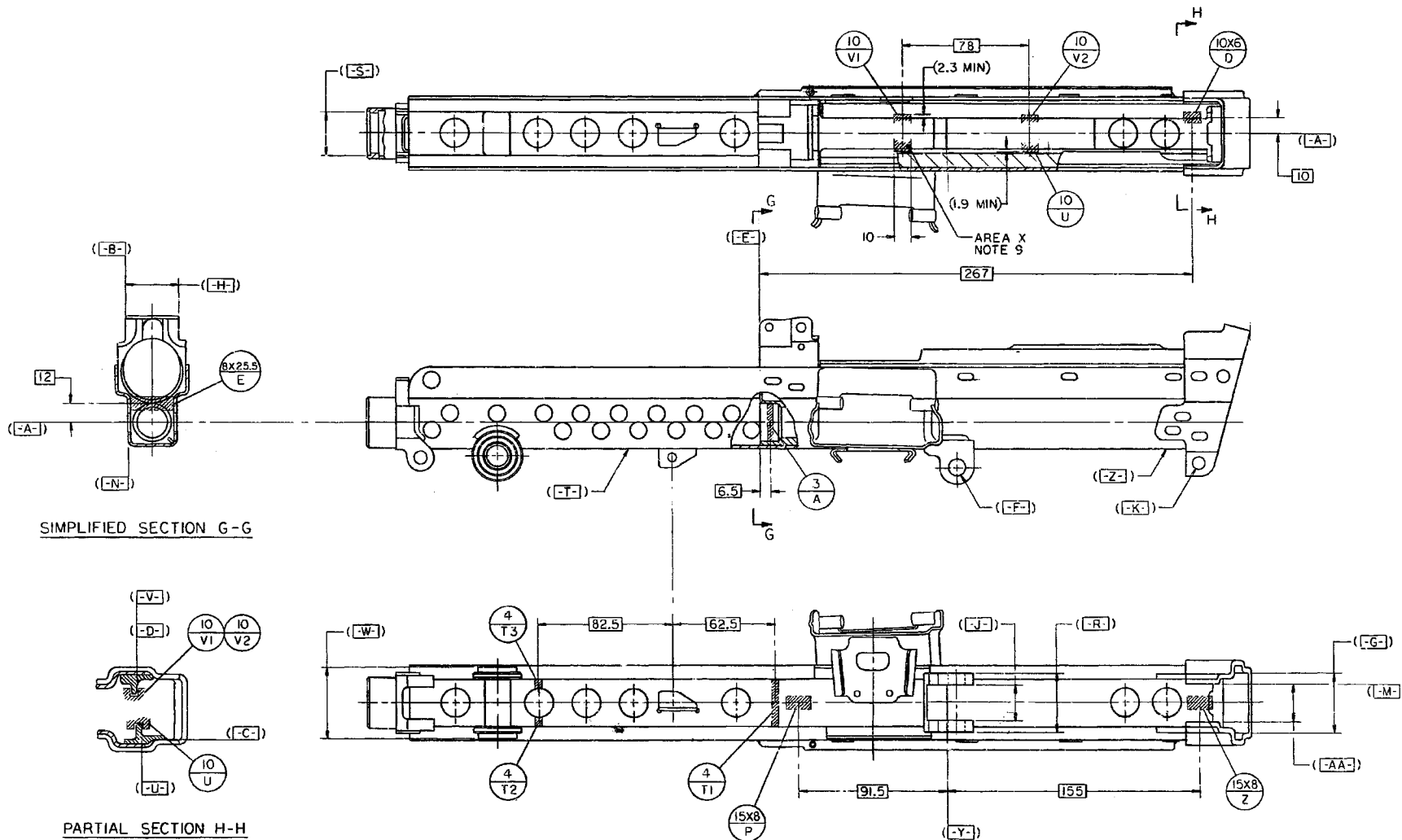
METRIC

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS		ORIGINAL DATE OF DRAWING 83-09-30		PART NO. 9348202 U S ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER OVER, NEW JERSEY 07081	
TP	TS	ES	RA	BN	RY	DRAFTSMAN [Signature]	CHECKER [Signature]
TOLERANCES ON DECIMALS =				TOLERANCES ON ANGLES =			
FRACTIONS =				THIRD ANGLE PROJECTION			
NEXT ASST				USED ON			
APPLICATION				SCALE 1/1 UNIT WT			
SHEET 3				SHEET 3			

3612101013 REV 09 / 19-08-83



REVISIONS			
SYM	DESCRIPTION	DATE	APPROV
---	PRODUCTION RELEASE ERR W352507	830930	168 JJS

**METRIC**

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF GRADING 85-09-30	PART TWO, 10-10-85 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DEVCOM, NEW JERSEY 07011	
TP	TO	CHANGES ARE IN MILLIMETERS	ORIENTATION	WH	CHECKED
CL	CL	TOLERANCES ON DECIMALS	DATE	DATE	DATE
PS	PS	FRACTIONS IN ANGLES	DATE	DATE	DATE
BS	BS	TYPED ANGLE PROJECTION	DATE	DATE	DATE
REVISION	REVISION		DATE	DATE	DATE
NEXT ARMY	LIBRARY ON		DATE	DATE	DATE
APPLICATION	FOR		DATE	DATE	DATE

RECEIVER  
(DATUM TARGET AREA)

SIZE F FSCM NO. 19200  
SCALE 1/1 INCH=1/2 INCH  
93-48202

## QUALITY ASSURANCE PROVISION (QAP)

(DARCOM - R 702 - 10)

## 1. COMMAND AGENCY

U.S. ARMY ARMAMENT R, D & E CENTER  
PICATINNY ARSENAL, NJ 07806 - 50002. THESE QAPS FORM PART OF DRAWING / SPECIFICATION  
INSPECTION SHALL BE CONDUCTED AS SPECIFIED HEREIN AND IN ACCORDANCE WITH REFERENCED DOCUMENTS.

9348202

AS SPECIFIED IN THE CONTRACT.

UNLESS OTHERWISE SPECIFIED HEREIN OR IN THE CONTRACT, THE PROVISION OF MIL - W -  
63150 SHALL APPLY AND ARE MADE A PART OF THIS DETAIL QAP.

## PART I LIST OF APPLICABLE DOCUMENTS

## LIST OF DRAWINGS

## NUMBER NOMENCLATURE

9348202	Receiver	(Inspection Position P)
9348203	Body, Receiver	(Inspection Position A)
9348204	Support, Barrel	(Inspection Position B)
9348205	Support, Gas Cylinder	(Investment Cast)
		(Inspection Position C)
9348206	Bushing, Front	(Inspection Position D)
9348207	Support, Trigger Frame	(Inspection Position E)
9348213	Body, Magazine Sleeve	(Inspection Position K)
9348214	Bushing, Magazine Sleeve	(Inspection Position L)
9348215	Support, Feed Box	(Inspection Position N)
9348208	Guide, Cocking Handle	(Inspection Position F)
9348209	Guide, Slide, Left	(Inspection Position G)
9348210	Guide, Slide, Right	(Inspection Position H)
9348211	Block, Rear	(Inspection Position J)
9348212	Sleeve Assembly, Magazine	(Inspection Position M)

## DISTRIBUTION STATEMENT A, UNLIMITED

## REVISIONS

4.RELEASE NUMBER	G1S2002R1	G5S2009	L7S4181											
5. DATE	921215	970516	980630											
4.RELEASE NUMBER														
5. DATE														
REVISION STATUS OF SHEETS	6. REVISION	F	F	F	F	F	F	F	F	F	F	F	F	F
	7. SHEET	1	2	3	4	5	6	7	8	9	10	11	12	13
	6. REVISION													
	7. SHEET													

## 8. QAP FOR:

RECEIVER : M249 M.G.

CAGE CODE  
19200

## 9. SUBMITTED BY:

ARDEC - SMCAR - QAF - S (D)

*William D. Brown*

## 10. QAP NO.

9348202

## 11. DATE

12 APR 93  
*William D. Brown*

## 13. RELEASE NO

W3S2507

## 14. PAGE NO.

1

## 15. NO OF PAGES

14

(DAR R 702 - 10)

**DARCOM FORM 2484-R**

# QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)

(DAR R 702 - 10)

## PART II QUALITY PROVISIONS

1. Responsibility for Inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specifications where such inspections are deemed necessary to assure supplies and service conform to prescribed requirements.

### 2. First Article Inspection.

2.1 Unless otherwise specified, a first article sampling consisting of five (5) items shall be submitted for inspection and approval in accordance with the terms of the contract. As determined by the Government, the sample items may be subjected to any or all of the examinations and tests specified in this QAP and be inspected for compliance with any of the requirements.

2.2 Rejection. If any sample item fails to comply with any of the applicable requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

### 3. Quality Conformance Inspection

3.1 Quality Conformance Inspection shall consist of inspection of all characteristics contained in Part III "Inspection Requirements" and Part IV "Certification Provisions" of this QAP.

3.1.1 All other quality characteristics not specifically listed herein are subject to inspection under the contractor's quality or inspection system.

76. REVISION SYMBOL AND DATE	CAGE CODE 19200					
	C . 921215	D . 950614	E . 970516	F . 980630		10. QAP NO. 9348202
						14. PAGE NO. 3

**QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)**  
(DAR R 702 - 10)

**PART III INSPECTION REQUIREMENTS**

**TABLE I CLASSIFICATION OF QUALITY CONFORMANCE CHARACTERISTICS**

100% examination shall be performed for critical characteristics unless otherwise stated. Examination for major and minor characteristics shall be performed in accordance with the classification of quality conformance characteristics contained herein. Inspection Level II shall be used and individual AQL's applied in accordance with MIL-STD-105.

<u>CLASS</u>	<u>CHARACTERISTICS</u>	<u>ZONE</u>	<u>AQL</u>	<u>INSPECTION METHOD</u>
--------------	------------------------	-------------	------------	--------------------------

**INSPECTION POSITION A: BODY, RECEIVER - DWG - 9348203**

**CRITICAL: NONE**

**MAJOR:**

101	Profile ( 0.4 ) of 37.94, 45 Degree	C-6	Sht.4 0.65	SMTE
102	Inside Width 26.75 , in area "X"	D-7	Sht.1 0.65	SMTE

**MINOR:**

201	Profile ( 0.3 ) of 68.25	B-4	Sht.3 1.5	SMTE
202	Profile ( 0.4 ) of 11.10	B-3	Sht.3 1.5	SMTE
203	Profile ( 0.4 ) of 239.15	B-3	Sht.3 1.5	SMTE
204	Profile ( 0.2 ) of 72.65	C-4	Sht.3 1.5	SMTE
205	Location ( 11.8 and 4.5 ) of Edge, Magazine Cutout	B-4, C-4	Sht.4 1.5	SMTE
206	Position ( 0.3 ) of 42.75	D-3	Sht.3 1.5	SMTE
207	Profile ( 0.4 ) of 249.3	F-8	Sht.3 1.5	SMTE
208	Profile ( 0.2 ) of 97.5	F-6, F-7	Sht.3 1.5	SMTE
209	All Markings Present and Proper		1.5	VISUAL
210	Profile ( 0.3 ) of 15.1	C-3	Sht.4 1.5	SMTE

16. REVISION SYMBOL AND DATE	C , 921215	D , 950614	E , 970516	F , 960630		CAGE CODE 19200  10. QAP NO: 9348202  14. PAGE NO: 4

# **QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)**

(DAR R 702-10)

211	Profile ( 0.3 ) of 7.925, in Area "Z" 2 Places	B-7	Sht.1	1.5	SMTE
212	Profile ( 0.2 ) Inside Area "Y", 2 Places	A-6, A-7	Sht.1	1.5	SMTE
213	Profile ( 0.43 ) of 48.185, 2 Places	C-7, C-8	Sht.1	1.5	SMTE
214	Thickness ( 1.75 ) of Receiver in Area W	F-7 NOTE 2	Sht.2	1.5	SMTE
215	Profile ( 0.2 ) of 36.96, 2 Places	C-7	Sht.1	1.5	SMTE
216	Width 16.0	D-5	Sht.1	1.5	SMTE
217	Length 99.0	B-2, B-3	Sht.1	1.5	SMTE
218	Profile ( 0.2 ) of 8.3	C-4, C-5	Sht.1	1.5	SMTE
219	Position ( 0.1 ) of 23.9 Width	C-2, C-3	Sht.1	1.5	SMTE
220	Straightness ( 0.12 ) , In Area U & V	C-8	Sht.2	1.5	SMTE
221	Length 20.00	E-1, E-3	Sht.1		
222	Position ( 0.2 ) of Diameter 6.2 , (8.5)	C-3	Sht.1	1.5	SMTE
223	Length 24.0	C-5	Sht.1	1.5	SMTE
224	Position ( 0.1 ) of 14.30 Width	D-4	Sht.1	1.5	SMTE
225	Height of 10.0	B-1	Sht.1	1.5	SMTE
226	Height of 5.5	C-1	Sht.2	1.5	SMTE
227	Width 6.0	C-2	Sht.2	1.5	SMTE
228	Depth of 2.55	B-2, B-3	Sht.2	1.5	SMTE
229	Workmanship ( see MILL-W-63150 )	C-1	Sht.1	1.5	SMTE
				2.5	VISUAL

## **INSPECTION POSITION B: SUPPORT, BARREL - DWG - 9348204**

**CRITICAL: NONE**

**MAJOR:**

101	Diameter ( 23.50 ) of Gas Cylinder Hole	D-8	Sht.2	0.65	SMTE
102	Position of Gas Cylinder Hole	D-8	Sht.2	0.65	SMTE
103	Profile ( 0.2 ) of Radius 17.2	D-1	Sht.1	0.65	SMTE
104	Width ( 20.20 )	B-2/3	Sht.1	0.65	SMTE
105	Position of 20.20 Width	B-2/3	Sht.1	0.65	SMTE
106	Diameter 5.035 of Barrel Latch Pivot Hole	D-5	Sht.1	0.65	SMTE
107	Position of 5.035 ( 5.95 & 45.85 )	C-5, D-5	Sht.1	0.65	SMTE
108	Length 26.05 , in Area "Z"	D-6	Sht.2	0.65	SMTE
109	Perpendicularity of Datum -C-	B-5	Sht.1	0.65	SMTE
110	Diameter 38.80 of Barrel Hole	F-8	Sht.2	0.65	SMTE
111	Position of Barrel Hole Diameter	F-8	Sht.2	0.65	SMTE

16. REVISION SYMBOL AND DATE	C	921215	D	950614	E	970516	F	980630	CAGE CODE 19200
									10. QAP NO. 9348202
									14. PAGE NO. 5

# **QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)**

(PAR R 702 - 10)

MINOR:

201	Width 20.00	D-7	Sht.1	1.5	SMTE
202	Position of 20.0 Width	D-7	Sht.1	1.5	SMTE
203	Profile ( 0.4 ) of 25.25	B-3	Sht.2	1.5	SMTE
204	Profile ( 0.24 ) of 76.8	B-4	Sht.1	1.5	SMTE
205	Profile ( 0.23 ) of 33.0	C-2	Sht.2	1.5	SMTE
206	Width 26.45	B-5	Sht.2	1.5	SMTE
207	Diameter 3.15 of Pin Hole	C-1	Sht.1	1.5	SMTE
208	Position of 3.15 Diameter Pin Hole	C-1	Sht.1	1.5	SMTE
209	Profile ( 0.43 ) of 78.375	C-4	Sht.2	1.5	SMTE
210	Profile ( 0.23 ) of 31.5 , 2 Places	B-6	Sht.2	1.5	SMTE
211	Workmanship (see MIL-W-63150)			2.5	VISUAL

**INSPECTION POSITION C: SUPPORT, GAS CYLINDER - DWG -9348205**

CRITICAL: NONE

MAJOR:

101	Diameter 27.10 of Gas Cylinder Hole	D-4	Sht.2	0.65	SMTE
102	Position of 27.10 Diameter	D-4	Sht.2	0.65	SMTE
103	Outside Diameter 31.60 of Gas Cylinder Hole	E-6	Sht.1	0.65	SMTE

MINOR:

201	Profile ( 0.2 ) of 7.3	D-6	Sht.1	1.5	SMTE
202	Position of 31.60 , Outside Diameter of Gas Cylinder	E-6	Sht.1	1.5	SMTE
203	Min Wall Thickness ( 1.46 ) , in Area "Y"	E-4	Sht.2	1.5	SMTE
204	Width 3.93	E-4	Sht.2	1.5	SMTE
205	Length 17.78 from -D-	F-4	Sht.2	1.5	SMTE
206	Diameter 8.04 of Retaining Pin Hole	D-2	Sht.2	1.5	SMTE
207	Position of 8.04 Diameter, Retaining Pin Hole	D-2	Sht.2	1.5	SMTE
208	Width 24.10 of Flats	B-7	Sht.1	1.5	SMTE
209	Position of 24.10 Flats	B-7	Sht.1	1.5	SMTE
210	Width 33.57	B-7	Sht.1	1.5	SMTE
211	Surface Roughness	F-6	Sht.1	1.5	SMTE
212	Workmanship			2.5	VISUAL

16. REVISION SYMBOL AND DATE		C , 921215	D , 950614	E , 970516	F , 980630					10. QAP NO: <b>9348202</b>
										14. PAGE NO <b>6</b>

# **QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)**

(DAR R 702 - 10)

**INSPECTION POSITION D: BUSHING, FRONT - DWG 9348206**

**CRITICAL: NONE**

**MAJOR:**

101	Diameter 13.035	C-1	0.65	SMTE
102	Diameter 23.88 , 2 Places	C-3	0.65	SMTE

**MINOR:**

201	Diameter 16.0	D-3	1.5	SMTE
202	Diameter 29.98	C-4	1.5	SMTE
203	Length 45.90	B-3	1.5	SMTE
204	Surface Roughness	C-1	1.5	SMTE
205	Workmanship ( See MIL-W-63150 )		2.5	VISUAL

**INSPECTION POSITION E: SUPPORT, TRIGGER FRAME - DWG - 9348207**

**CRITICAL: NONE**

**MAJOR:**

101	Diameter 11.3 of Holes , 2 Places	B-2	0.65	SMTE
102	Position of Holes , 2 Places	B-2	0.65	SMTE
103	Width 23.24 between Legs	B-8	0.65	SMTE

**MINOR:**

201	Thickness 3.93 of Cross Member	B-3	1.5	SMTE
202	Length 30.0	C-3	1.5	SMTE
203	Width 36.32	B-7	1.5	SMTE
204	Workmanship ( See MIL-W-63150 )		2.5	VISUAL

**INSPECTION POSITION F: GUIDE, COCKING HANDLE - DWG - 9348208**

**CRITICAL: NONE**

**MAJOR: NONE**

**MINOR:**

201	Diameter, ( 3.188 ) Pin Holes 2 Holes	E-6	Sht.1	1.5	SMTE
202	Position ( 0.07 ) of Pin Hole	E-6	Sht.1	1.5	SMTE
203	Profile ( 0.2 ) of 3.5	E-3	Sht.2	1.5	SMTE
204	Width 13.5	F-6	Sht.2	1.5	SMTE
205	Position ( 0.24 ) of 13.5 Width	F-6	Sht.2	1.5	9350154
206	Width 2.1	E-5	Sht.2	1.5	SMTE
207	Width 9.0	F-4	Sht.2	1.5	SMTE
208	Thickness 8.4 , 2 Places	D-3	Sht.2	1.5	SMTE
209	Surface Roughness, 1.6 , 2 Places	E-5	Sht.2	1.5	SMTE
210	Workmanship ( See MIL-W-63150 )			2.5	VISUAL

16. REVISION SYMBOL AND DATE	CAGE CODE 19200				
	C , 921215	D , 950614	E , 970516	F , 980630	10. QAP NO. 9348202
					14. PAGE NO. 7



**QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)**  
(DAR R 702 - 10)

**INSPECTION POSITION G: GUIDE, SLIDE, LEFT - DWG - 9348209**

**CRITICAL: NONE**

**MAJOR:**

101	Profile ( 0.24 ) of 2.98	C-5,	C-6	Sht.2	0.65	SMTE
102	Chromium Plating Thickness ( 0.045 ) in area specified	Note 7A		Sht.1	0.65	SMTE
103	Diameter 5.025		C-2	Sht.2	0.65	SMTE
104	Position of 5.025 Diameter		C-2	Sht.2	0.65	SMTE
105	Profile ( 0.16 ) of 13.55		B-3	Sht.2	0.65	SMTE
106	Profile ( 0.2 ) of 1.55		D-4	Sht.2	0.65	SMTE
107	Profile ( 0.22 ) of 8.53		B-6	Sht.1	0.65	SMTE

**MINOR:**

201	Profile ( 0.26 ) of 7.28		C-6	Sht.2	1.5	SMTE
202	Profile ( 0.2 ) of 11.51	B-6,	B-7	Sht.2	1.5	SMTE
203	Width 3.157		C-6	Sht.2	1.5	SMTE
204	Depth 8.52 of 5.025 Diameter		B-3	Sht.2	1.5	SMTE
205	Width 1.36 of Spring Slot		E-4	Sht.2	1.5	SMTE
206	Profile ( 0.24 ) of 16.58		E-4	Sht.2	1.5	SMTE
207	Profile ( 0.16 ) of 6.64		F-5	Sht.2	1.5	SMTE
208	Profile ( 0.3 ) of 237.6		D-3	Sht.1	1.5	SMTE
209	Profile 0.25 of Datum -B- (Unrestrained)		E-6	Sht.1	1.5	SMTE
210	Profile 0.25 of Datum -A- (Unrestrained)		C-6	Sht.1	1.5	SMTE
211	Workmanship ( See MIL-W-63150 )				2.5	VISUAL

**INSPECTION POSITION H: GUIDE, SLIDE, RIGHT - DWG - 9348210**

**CRITICAL: NONE**

**MAJOR:**

101	Profile ( 0.22 ) of 3.01		B-8	Sht.1	0.65	SMTE
102	Distance 8.53		E-5	Sht.1	0.65	SMTE
103	Chromium Plating Thickness ( 0.035 )	Note 6A		Sht.1	0.65	SMTE

**MINOR:**

201	Profile ( 0.22 ) of 11.5		C-8	Sht.1	1.5	SMTE
202	Profile ( 0.36 ) of 11.0		C-8	Sht.1	1.5	SMTE
203	Profile ( 0.3 ) of 237.6		E-3	Sht.1	1.5	SMTE
204	Diameter 3.1 of Hinge Hole		C-1	Sht.1	1.5	SMTE
205	Position of 3.1 Diameter		C-1	Sht.1	1.5	SMTE
206	Profile ( 0.45 ) of 124.5		C-4	Sht.1	1.5	SMTE
207	Profile 0.25 of Datum -B- (Unrestrained)		D-3	Sht.1	1.5	SMTE
208	Profile 0.25 of Datum -A- (Unrestrained)		F-3	Sht.1	1.5	SMTE
209	Workmanship (See MIL-W-63150)				2.5	VISUAL

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**INSPECTION POSITION J: BLOCK, REAR - DWG - 9348211**

**CRITICAL: NONE**

**MAJOR:**

101	Diameter 6.35 of Weld Holes , 4 Holes	A-5	Sht.1	0.65	SMTE
102	Position of 6.35 Diameter Weld Holes, 4 Holes	A-5	Sht.1	0.65	SMTE
103	Diameter 6.35 of Weld Holes , 4 Holes	A-7	Sht.1	0.65	SMTE
104	Position of 6.35 Diameter , Weld Holes 4 Holes	A-7	Sht.1	0.65	SMTE
105	Profile ( 0.2 ) of 7.925	E-4	Sht.1	0.65	SMTE
106	Profile ( 0.2 ) of 7.925,	C-5	Sht.1	0.65	SMTE
107	Width 37.35 , Inside Area "Z"	E-4	Sht.1	0.65	SMTE
108	Profile ( 0.08 ) of 1.1 , 3.07 , 12 Degrees , Both Sides	D-3,	F-4	Sht.2	0.65 SMTE

**MINOR:**

201	Distance 3.95 of Recess for Cover Latches, Both Sides	C-4,	E-3	Sht.2	1.5 SMTE
202	Depth 2.20 of Recess for Cover Latches, Both Sides	C-4,	E-4	Sht.2	1.5 SMTE
203	Thickness 2.97 of Legs	Note 2 Sht.1 1.5 SMTE			
204	Profile ( 0.1 ) of 21.25 , 16 Degrees	E-8 Sht.1 1.5 SMTE			
205	Workmanship ( See MIL-W-63150 )	2.5 VISUAL			

**INSPECTION POSITION K: BODY, MAGAZINE SLEEVE - DWG -9348213**

**CRITICAL: NONE**

**MAJOR:**

101	Height 22.8 , Magazine Opening	E-5 Sht.1 0.65 SMTE			
102	Length 64.76 , Magazine Opening	E-4, E-5 Sht.1 0.65 SMTE			
103	Length 60.6	F-4, F-5 Sht.1 0.65 SMTE			

**MINOR:**

201	Length 8.0 , Cutout for Bushing Both Sides	D-4,	D-6	Sht.1	1.5 SMTE
202	Profile ( 0.44 ) of 27.6	D-7,	D-8	Sht.2	1.5 SMTE
203	Height 4.7 of Offset Leg	B-4 Sht.1 1.5 SMTE			
204	Workmanship ( See MIL-W-63150 )	2.5 VISUAL			

**INSPECTION POSITION L: BUSHING, MAGAZINE SLEEVE - DWG 9348214**

**CRITICAL: NONE**

**MAJOR: NONE**

**MINOR:**

201	Outside Diameter 7.70	C-2	1.5	SMTE		
202	Inside Diameter 3.10					
203	Length 15.75					
204	Workmanship (See MIL-W-63150)					
				B-2	1.5	SMTE
				B-3	1.5	SMTE
					2.5	VISUAL

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# QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)

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## INSPECTION POSITION M: MAGAZINE SLEEVE ASSEMBLY - DWG - 9348212

CRITICAL: NONE

MAJOR:

All Components Present, Correct,  
and Properly Assembled

0.65 VISUAL

MINOR:

201	Height 22.95 , 2 Places	B-6	1.5	SMTE
202	Location 12.75	C-5	1.5	SMTE
203	Width 39.40 Between Bushings	C-4, C-5	1.5	SMTE
204	Profile (0.45) to Datums	D-4	1.5	SMTE
205	Position of 3.1 Diameter	C-6	1.5	SMTE
206	Workmanship ( See MIL-W-63150 )		2.5	VISUAL

## INSPECTION POSITION N: SUPPORT, FEED BOX - DWG - 9348215

CRITICAL: NONE

MAJOR: NONE

MINOR:

201	Profile ( 0.65 ) of 5.17 Height	D-3 Sht.1	1.5	SMTE
202	Angularity ( 0.1 ) of 4.0 , 45 Degrees 2 Places	B-3, D-3 Sht.2	1.5	SMTE
203	Length 7.95 of Legs , 2 Places	C-2, E-4 Sht.2	1.5	SMTE
204	Thickness 1.75	NOTE 2	1.5	SMTE
205	Workmanship ( See MIL-W-63150 )		2.5	VISUAL

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## INSPECTION POSITION P: RECEIVER - DWG - 9348202

CRITICAL: NONE

### MAJOR:

101	Profile ( 0.6 ) of 237.2	B-7	Sht 1	0.65	12923173
102	Width ( 19.6 ) Between Rails	E-2	Sht 1	0.65	9350156 / SMTE
103	Position ( 1.0 ) of Datum -J-, 18.39 , 27	B-7	Sht 1	0.65	12923173 / 12923088
104	Profile ( 0.46 ) of 28.225 in Area "S"	F-1	Sht 1	0.65	12923102
105	Position ( 0.4 ) of 121.11 , (Ø 11.3 )	B-4	Sht 1	0.65	12923102
106	Functional Condition of Holes to Backface of Rear Block	NOTE 9		0.65	12923101
107	Diameter ( 8.050 ) thru, Lower Holes	D-8	Sht 3	0.65	SMTE
108	Position ( Ø 0.4 , Ø 0 ) of Diameter 8.050 , Lower Holes	D-8	Sht 3	0.65	12923102 / SMTE
109	Diameter ( 8.050 ) thru, Upper Holes	E-8	Sht 3	0.65	SMTE
110	Profile ( 0.4 ) of 3.0 , Entire Length	B-8	Sht 3	0.65	12923166 / 9350156
111	Profile ( 0.5 ) of Datum -A-, in Area "H"	B-5	Sht 3	0.65	12923166 / 9350156
112	Position ( 0.3 ) of Diameter 3.005 , 40.84, in Area "Z"	C-4	Sht 3	0.65	12923102
113	Profile ( 0.5 ) of 12.35 , in Area "Y"	D-6	Sht 4	0.65	12923175
114	Profile ( 0.2 ) of 26.05	F-3	Sht 4	0.65	12923166
115	Profile ( 0.4 ) of 261.35 , 2 places	D-2	Sht 1	0.65	12923102
116	Functional Condition Between Guides	Note 8		0.55	9350156
117	Width 22.55 Min, in Area "X" of ( 22.80 )	B-4	Sht 3	0.65	12923171
119	Profile ( 0.6 ) of 16.962	B-5	Sht 3	0.65	SMTE
119	Profile ( 0.4 ) of 41.91, in Area "L"	D-5	Sht 2	0.65	SMTE
120	Salt Spray				See 505
121	Coating Weight				See 506
123	Supplemental Oil				See 507
124	All Components Present & Properly Assembled			0.65	VISUAL

### MINOR:

201	Position ( 0.3 ) of Diameter 13.035, R282.08	B-5	Sht 1	1.5	9350155
202	Diameter ( 6.035 )	D-4	Sht 1	1.5	SMTE
203	Position ( 0.16 ) of Diameter 6.035, 26	C-5	Sht 1	1.5	12923166
204	Profile ( 0.6 ) of 26.33, in Area "M" 2 Places	D-1	Sht 1	1.5	12923102
205	Profile ( 0.6 ) of 22.0	E-5	Sht 1	1.5	12923102
206	Width ( 24.40 )	D-8	Sht 2	1.5	SMTE
207	Position ( 0.17 ) of Datum -L-	B-5	Sht 2	1.5	12923170
208	Position ( Ø 0.08 ) of Diameter 8.050 , Upper Holes	E-8	Sht 3	1.5	12923168 / SMTE
209	Profile ( 0.6 ) of 18.0 , in Area "J"	B-3	Sht 2	1.5	12923102
210	Profile ( 0.4 ) of 37.66 , in Area "K"	D-5	Sht 3	1.5	12923102
211	Angularly ( 0.2 ) of 37.66 in Area "K"	D-5	Sht 3	1.5	SMTE
212	Profile ( 0.27 ) of 0.06 , in Area "N"	D-5	Sht 1	1.5	12923172
213	Width ( 32.75 )	F-4	Sht 4	1.5	SMTE
214	Profile ( 0.6 ) of Datum -A-, Outside Area "H"	B-5	Sht 3	1.5	12923166
215	Protective Finish			1.5	VISUAL
216	Workmanship (See MIL-W-63150)			2.5	VISUAL

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**QUALITY ASSURANCE PROVISION (QAP) – (CONTINUATION SHEET)**  
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**TABLE II SPECIAL SAMPLING INSPECTION**

Dimensional control of cast parts. In place of the normal sampling associated with the Classification of Defects, and with the approval of the Contracting Officer, a sample of at least ten (10) parts (as cast) from each cavity shall be dimensionally inspected to qualify a new or reworked cavity for use in production or as a control of the cavity during production. In addition, a random sample of five (5) parts from each cavity after production of 5,000 consecutive parts from each cavity shall be selected for dimensional inspection as a control of the cavity during production. Individual cavity identification shall be provided.

If any defective parts are found during qualification of the cavity, the cavity producing the defective part will not be used in production. If any defective parts are found when inspection is performed for control of the cavity, the cavity producing the defective part shall be removed from production. Further, that portion of production since the last control check shall be returned to the contractor for corrective action.

All cavities formerly removed from production because of some fault may, after reworking, be returned to production providing they pass the qualification test specified above. The contractor may request a change of inspection frequency providing he presents objective evidence to substantiate the request to the Contracting Officer.

NOTE: This casting inspection does not apply to characteristics which are defined as "Critical"; characteristics which are created by machining; characteristics which are visually inspected; and characteristics for surface finish.

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**PART V TEST METHODS AND PROCEDURES**

501 Characteristics Major 101 through 113 of position '0' shall be inspected before painting.

502 The contractor shall perform the magnetic particle inspection after the product has been prepared according to MIL-I-6868.

**503 HARDNESS**

Five samples shall be selected from each heat treatment batch. Testing shall be in accordance with ASTM E18. Each heat treatment batch shall remain segregated until all tests are completed. If any sample fails to comply with the hardness requirements, it shall be classified as defective and the lot shall be rejected. A heat treatment batch is defined as parts that have been heat treated at the same time in the same furnace and quench bath for all phases of the heat treatment process.

**504 CASE DEPTH HARDNESS**

Three (3) samples shall be selected from each day's production from each carburizing furnace or salt pot used. Each sample shall be cut perpendicular to the cased surface and the cut surface shall then be prepared by grinding or rough polishing to remove the effects of the original cut. Etching will be done with a weak solution (1-10%) Nitric acid in alcohol and of sufficient time to develop a contrast in case and core structure. The depth of case shall be the total distance of penetration from the surface to the nearest point of uniform core structure as measured on a polished and etched specimen at a magnification not lower than 10 diameters. If any sample fails to comply with the specified requirements, it shall be classed defective and the lot shall be rejected.

**505 SALT SPRAY TEST**

Five (5) parts shall be selected from each lot. The test shall be performed as specified in DOD-P-16232 and ASTM B 117 without the supplemental oil. Test procedures and equipment shall have the prior approval of the Government. If any part shows evidence of corrosion, it shall be classified as defective and the entire lot shall be rejected.

**506 COATING WEIGHT**

Five (5) samples or five test panels shall be selected from each lot. The test shall be performed as specified in DOD-P-16232. Test procedures and equipment shall have the prior approval of the Government. If any sample does not meet the requirement of DOD-P-16232, it shall be classified as defective and the lot shall be rejected.

**507 SUPPLEMENTAL OIL TREATMENT SALT SPRAY**

The test shall be performed for first article and at least semi-monthly during production. Three test panels from each processing tank or dispenser shall be prepared and tested in accordance with MIL-L-3150 or MIL-C-16173 (as applicable) and ASTM B117 using a 5% salt solution. The test duration and accept/reject criteria shall be as specified in the applicable specification. If any test panel fails to meet the applicable requirement, all items processed since the last acceptable test shall be rejected.

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